ABSTRACT

Printed products are accurately detected, counted and tracked as they move from a gripper conveyor to a lay down conveyor. The printed products are further tracked from a position where they reach a sensor upstream of the stacker where the position of selected printed products is provided to the stacker, together with a flag for those selected printed products, to assure that all of the stacker operations, including product stream interception, turntable rotation and bundle ejection, are performed with precision. Counting and tracking are performed by different sensors upstream relative to the stacker and the tracking function is transferred to the stacker when a flagged signature reaches a nip of the stacker infeed. Counting of printed products by the stacker is eliminated.